

Delrin 1 1/4"

W/ 144890

Work Order ID 148284

148284

Tuesday, June 28, 2016 9:00:45 AM

Item ID: D2002-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Knob

Start Date: 6/20/2016 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 04 2016 Tooling: _____ Date: _____
QC: 9.89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2002	Rev A

100 0.00

100

Doosan

Doosan Lathe

Memo

1-Turn as per folio FA005 & dwg

FOLIO REV: AA

DWG REV: B

2-Deburr as required

0.15

23

φ

DAS

45

9-89

2016-7-21

110 0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

23

φ

DAS

45

9-89

2016-7-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 148284

Tuesday, June 28, 2016 9:00:45 AM

148284

Page 2

Item ID: D2002-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Knob
 Start Date: 6/20/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/27/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				23	Ø		DAS 49 9-89 16/07/22
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : GA	0.00 0.01				23			DAS 6 9-89 JUL 25 2016
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							DAS 21 9-89 JUL 25 2016

DAS
21
9-89
JUL 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																									

Picklist Print

Tuesday, June 28, 2016 9:00:44 AM

Page 1

Work Order ID: 148284

148284

Parent Item: D2002-015

D2002-015

Parent Item Name: Knob

Start Date: 6/20/2016

Required Date: 6/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.05.18Added inspection level 8EC
IPP Rev:D Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No				f	3.5476		0.2			

MDFI RINR1 2500

DELRIN ROUND BAR 1.25" color: black

Location	Loc Qty	Loc Code
MAT	0.9836	
m133285	0.9836	
MAT039	2.564	
m131782	2.564	

m135214

1.125[#]

DAS
45 2016-7-21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

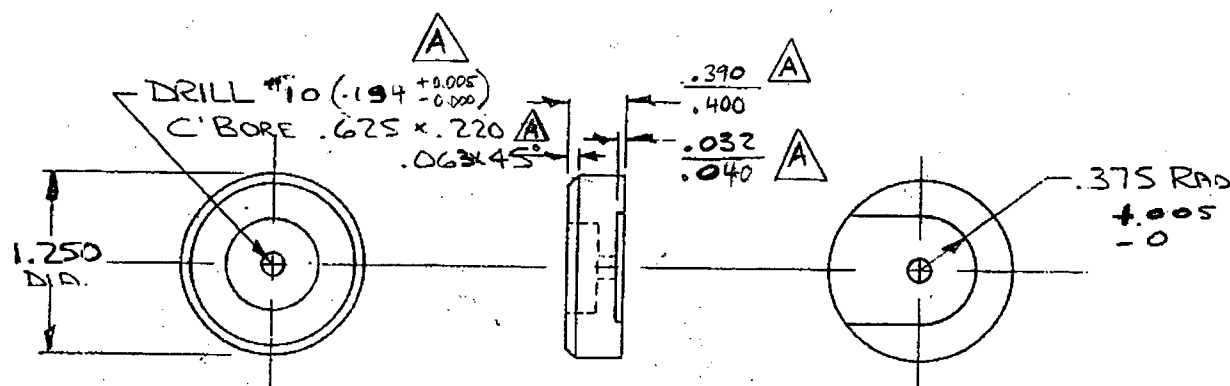
QA Closed: _____ Date: _____

Work Order update only ☐

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RELEASED

79.12.09 DS



DETAIL OF D2002-015

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148284 MJS

16-07-04

4/F: BLACK DELRIN OR
BLACK UHMW PER D2689



D2002-015

REVISION DRAWN CHECKED APPROVED DESCRIPTION OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO. REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES IN 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER MIL. S. 1117 5. HOLE PER AND 10187		1. TOLERANCES — 2. ANGLES 3. PARALLELISM 4. ECCENTRICITY 5. SYMMETRY ABOUT ALL M.T.C. CENTER LINES .015		RVET CODE SHALL BE PER NAS 523 BASIC CODE D-DIMPLE RIGHT OF SHEETS C-COMPOSITE BASIC CODES BL-M120H FORD DB-M120A2RAD		QTY. REQUIRED APPROVAL		PART NO. ITEM DESCRIPTION MATERIAL SPEC/VENDOR		CONTRACT NO. DRAWN DESIGN STRESS CHECKED CLIENT		DATE 9/10/08 TITLE KNOB DWG NO. D2002 SCALE 1:1 SHEET 1 OF 2	
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REPORT ALL DISCREPANCIES — DO NOT SCALE